

**Work Order ID 57611-1**

Friday, April 09, 2010 2:44:09 PM



Page 1

Item ID: D4016-1

Revision ID:

Item Name: Hinge Half, Base

SPLIT

Accept



Setup



Start



Stop



Start Date: 4/12/2010

Start Qty: 12.00 2



Required Date: 4/13/2010

Req'd Qty: 12.00 2



Reference:

Cust Item ID:

Customer:

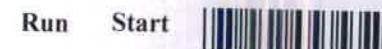
Approvals: Process Plan: *MF*

Date: 10-4-9

Tooling:

Date:

Run



Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

Operation

Description

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr Revision Nbr

D4016 A

100

Cut blanks as per folio

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.00" LONG

0.00

*10/04/10*

12 0

110



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: *MF*DWG REV: *A*

0.00

*10-4-13*

②

DEBURR

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 57611

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Page 2

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Item Name: Hinge Half, Base

Start Date: 4/12/2010 Start Qty: 12.00

Required Date: 4/13/2010 Req'd Qty: 12.00

Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date: Tooling: Date:

Run

Start



QC:

Date: SPC (Y/N): Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

MF 10-4-13

②

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

MF 10-4-13

2 0

160



Packaging

Packaging

Identify as per dwg & Stock Location: best fit

0.00

Memo

0.00

② PD 10.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 57611**

Friday, April 09, 2010 2:44:09 PM



Page 3

Item ID: D4016-1

Revision ID:

Item Name: Hinge Half, Base

Start Date: 4/12/2010 Start Qty: 12.00

Required Date: 4/13/2010 Req'd Qty: 12.00

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan:

Date: Tooling: Date:

Run Start



QC:

Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Memo

0.00

10/04/15  
MF  
10-4-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

# Picklist Print

Friday, April 09, 2010 2:44:08 PM

Page 1

Work Order ID: 57611



Parent Item: D4016-1



Parent Item Name: Hinge Half, Base

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B  
as per dwg REV.A DD 10.02.22 verified by:EC

Start Date: 4/12/2010

Required Date: 4/13/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased				100	f	16.3000	1.0105			

304 bar 1.50 X1.50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT54	16.3	
108381	12	
112752	4.3	

1.0105 and 10/04/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57611
Description: HINGE HALF, BASE	Part Number:	D4016-1
Inspection Dwg:	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Measured by:	<i>dd</i>	Audited by:	<i>BB</i>	Prototype Approval:	N/A
Date:	<i>10-4-13</i>	Date:	<i>10/04/13</i>	Date:	N/A
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	



## Value stream mapping

- Value stream mapping is **the best way to identify where the high payoff** opportunities are, yet value stream mapping is the lean tool most likely to **not be used by** companies doing pretend lean!

8

7

6

5

4

3

2

1

D

D

C

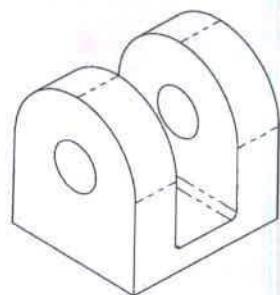
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B

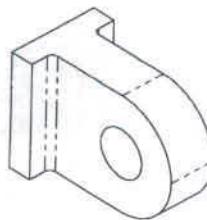
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A

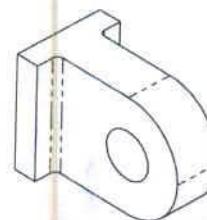
A



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASED  
2010-02-16  
MJD

A	NEW ISSUE		JPX	10.01.29
REV.	DESCRIPTION		BY:	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	CC	DRAWING NO.		
MFG. APPR.	BD	D4016	REV. A	
APPROVED	WJ	TITLE	SHEET 1 OF 2	
DE APPR.	MM	BASKET HINGE	SCALE	
DATE	10.01.29		NTS	

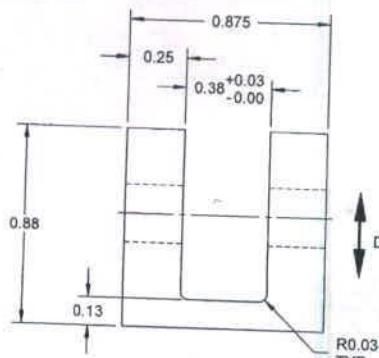
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

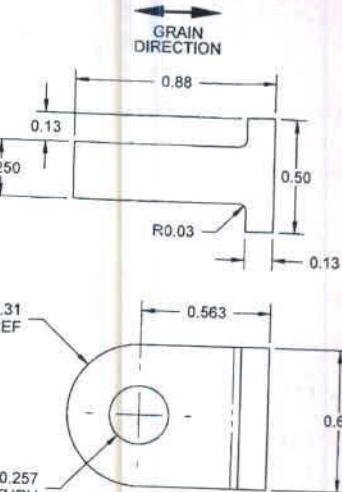
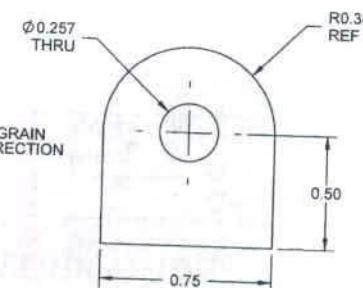
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

- 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B
- 5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221
- REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.09 lbs  
-3: 0.04 lbs  
-5: 0.01 lbs

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>R</i>	
MFG. APPR.	<i>BS</i>	REV. A
APPROVED	<i>W</i>	SHEET 2 OF 2
DE APPR.	<i>W</i>	TITLE
DATE	10.01.29	SCALE
		NTS
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RELEASED  
2010-02-16

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